

Ship June 15

Work Order ID 67539

Monday, March 28, 2011 9:49:34 AM



Page 1

Item ID: D2281

Accept



Setup Start



Revision ID:

Item Name: Jack Saddle

Stop



Start Date: 3/28/2011 Start Qty: 150.00



Cust Item ID:

Required Date: 4/4/2011 Req'd Qty: 150.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date:

11-03-28

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2281

Rev G

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2281

☐ Dwg Rev: *G*

☐ Prog Rev: *G*

☐ 2-

Debur if necessary

304.082

B11-3-31

(168)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-3-31

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Subtotal

count
(168)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Accept



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Stop



Item Name: Jack Saddle

Start Date: 3/28/2011 Start Qty: 150.00



Cust Item ID:

Required Date: 4/4/2011 Req'd Qty: 150.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Debur								
140		0.00							
	NC BRAKE								
Brake NC	Memo	0.00							
Brake NC	Form as per D2281 using D2281-T2								
150		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

N/A

SB 11/04/05

168

11 04 11 168 Counted

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 67539

Page 3

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Accept



Setup Start



Revision ID:

Stop



Item Name: Jack Saddle

Start Date: 3/28/2011 Start Qty: 150.00



Cust Item ID:

Required Date: 4/4/2011 Req'd Qty: 150.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

Packaging

4/4/12 160

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/1211.04.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Monday, March 28, 2011 9:49:40 AM

Page 1

Work Order ID: 67539



Parent Item: D2281



Parent Item Name: Jack Saddle



Start Date: 3/28/2011

Required Date: 4/4/2011

Start Qty: 150.00

Required Qty: 150.00

Comments: IPP Rev:A Removed from 9 Digit 05-12-02 JLM
IPP: rev B ☐ 06.07.17 ☐ waterjet ☐ EC ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S14GA  304SS sheet .080		Purchased	No			100	sf	52.0000	0.125	19.73684	22,		
											11-3-31		

Location

Loc Qty

Loc Code

MAT020

52

113295

52

113295

168

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	
Description: Jack Saddle		Part Number:	D2281
Inspection Dwg: D2281 Rev: G		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.468	+/-0.010	4.477	✓		V HB02	
4.114	+/-0.010	4.118	✓		V	
2.933	+/-0.010	2.93			V	
1.535	+/-0.010	1.538	✓		V	
0.354	+/-0.010	0.351	✓		V	
0.354	+/-0.010	0.354	✓		V	
0.604	+/-0.010	0.604	✓		V	
2.000	+/-0.010	1.998	✓		V	
3.396	+/-0.010	3.396	✓		V	
3.646	+/-0.010	3.646	✓		V	
4.000	+/-0.010	4.006	✓		V	
1.525	+/-0.010	1.524	✓		V	
2.475	+/-0.010	2.477	✓		V	
Ø0.323	+0.006/-0.001	0.326	✓		V	
0.080	+/-0.010	0.083	✓		V	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 11-3-31	Date: 11/04/01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.08	New Issue	KJ/JLM	

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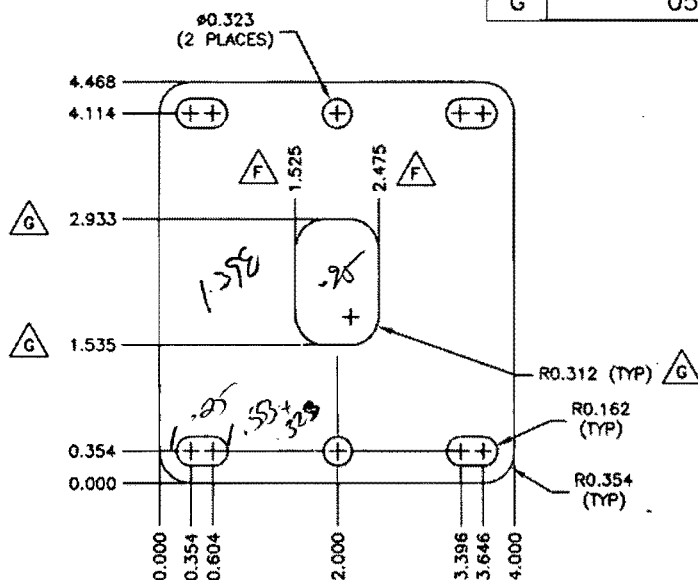
NOTE: Date & initial all entries



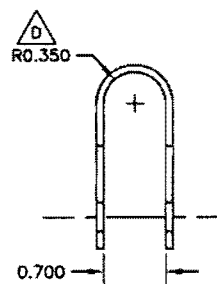
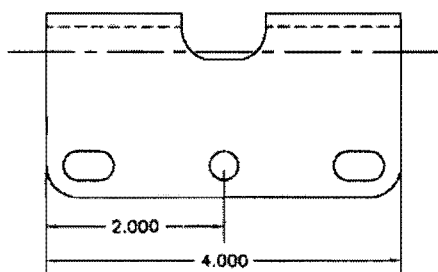
DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>UP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2281	REV. G SHEET 1 OF 1
DATE 05.06.07	TITLE JACK SADDLE		SCALE 1:2
A	94.10.14	NEW ISSUE	
B	94.10.18	DIMENSION WAS 2.878	
C	94.11.04	ADD TOOLING NOTCH	
D	98.03.27	R0.350 WAS R0.280	
E	04.11.18	REMOVE TOOLING NOTCHES	
F	05.03.16	REDESIGN FLAT PATTERN	
G	05.06.07	REDESIGN FLAT PATTERN	

RELEASED

05/08/11



FLAT LAYOUT



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 47339

Pl 11-03-21

D2281 JACK SADDLE

- 1) MATERIAL: 304/316 SS, 0.080 THICK (REF DART SPEC. M304S14GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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